

Work Order ID 70327

Thursday, June 02, 2011 2:52:08 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step. Long RH

Start Date: 6/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

5492-6
0.00

DC

Memo

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

8/11/2/11

for CL 11-6-27

110

0.00



Large Fab

0.00

Large Fab

Memo

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719. weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

1114703
1115928

11.06.15 10
11.06.15
11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 8 2E/06/16

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/06/16

710
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11-06-16 10 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD 11-06-16

16

Quality Control

180

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R: Aluminum Rod: 1114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11-07-04

10

p

11-07-04

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S 6/7/06

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 6/7/06

(K)

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X Ø M-L 11/07/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC, Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

4:00

0.00

OVEN TEMPERATURE:

320

0 F

FINISH TIME:

4:30

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10X 10/07/06

10 11-7-7.

10/07/07

Work Order ID 70327

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Required Date: 7/8/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/14/11 SP (10)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sub 111

10
RH

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: Italy

REOB

11/7/11 SP (10)

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Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11
mf
11-07-11

Picklist Print

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Page 1

Work Order ID: 70327

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22: New issue: KJ/RF:1
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	10			
Step D3067-1 		Manufactured	No			110	Each	95.0000	1	10			
End Plate													

Location	Loc Qty	Loc Code
WA	2	
67582	2	
WA016	93	
68214	93	

D3219-1 		Manufactured	No			110	Each	144.0000	2	20			
Plate													

Location	Loc Qty	Loc Code
WA	24	
68202	24	
WA017	120	
68338	120	

370325
 11-06-06
 70325

11-06-14

11-06-14

16
 4

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 70327

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1
Spacer
Manufactured No

180 Each

109.0000 2 20

Location

Loc Qty

Loc Code

WA

109

68337

28

69738

81

MS20600-AD4W4
Rivets
Purchased No

180 Each

2,128.000 16

Location

Loc Qty

Loc Code

ST321

2123

116188

123

117364

1000

117601

200

117885

800

WA018

5

116712

5

D3065-041
Step Leg Assembly Hi
Manufactured No

180 Each

8.0000 1 10

Location

Loc Qty

Loc Code

WA

8

66149

0

67503

8

K/Ae

x20
K/Ae

x160

K/Ae

869740 *x10*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 70327

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180 Each

95.0000

1 10



End Plate

11.07.04

Location Loc Qty Loc Code

WA 2

67582 2

WA016 93

68214 93

AN3-35A

Purchased No

250 Each

181.0000

2



Bolt

10
20

Location Loc Qty Loc Code

ST353 181

117313 31

117441 50

117619 50

117794 50

D3235-1

Manufactured No

250 Each

81.0000

2



Mounting Lug

20

Location Loc Qty Loc Code

ST471 81

68292 81

D3278-041

Manufactured No

250 Each

78.0000

1



Support Assembly

20

11/7/11 SP (10)

Location Loc Qty Loc Code

ST471 78

68957 38

69741 40

10

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Page 3

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16

160

Washer

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

40

Washer

AN5-36A Purchased

No

250

Each

151.0000

2

20

Bolt

Location

Loc Qty

Loc Code

ST341

151

117366

101

117794

50

D2618

Manufactured

No

250

Each

121.0000

2

20

Bushing

Location

Loc Qty

Loc Code

ST019

121

68249

58

69880

63

D2230-3

Manufactured

No

250

Each

98.0000

4

40

Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

94

68246

94

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Page 4

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Page 5

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

167.2696 1.2



Abraison Strip



11/7/11 SP

Location

Loc Qty

Loc Code

ST403 166.6

68076 166.6

ST409 0.6696

63735 0.6696

✓

20

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

2,531.000 2



Nut

Location

Loc Qty

Loc Code

ST300 2531

116391 11

116540 56

116549 764

117441 800

117601 400

117885 500

20

AN4-13A

Purchased No

250 Each

134.0000 8



Bolt

Location

Loc Qty

Loc Code

ST357 134

117628 134

11/7/11 SP 900

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Shop Packet Print

Page 5

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Start Date: 6/10/2011

Required Date: 7/8/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,192.000

2

20



Nut



M115594

[Handwritten signature]

Location

Loc Qty

Loc Code

ST300

1192

116105

232

116548

260

117441

500

117591

100

117611

100

16

MS21042L4

Purchased

No

250

Each

5,791.000

8

80



Nut



80

Location

Loc Qty

Loc Code

ST300

5791

116823

491

117441

3000

117601

800

117885

1500

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40



Washer



M1172211171 SP 70

W/O:		WORK ORDER CHANGES					
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DESIGN <i>CP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

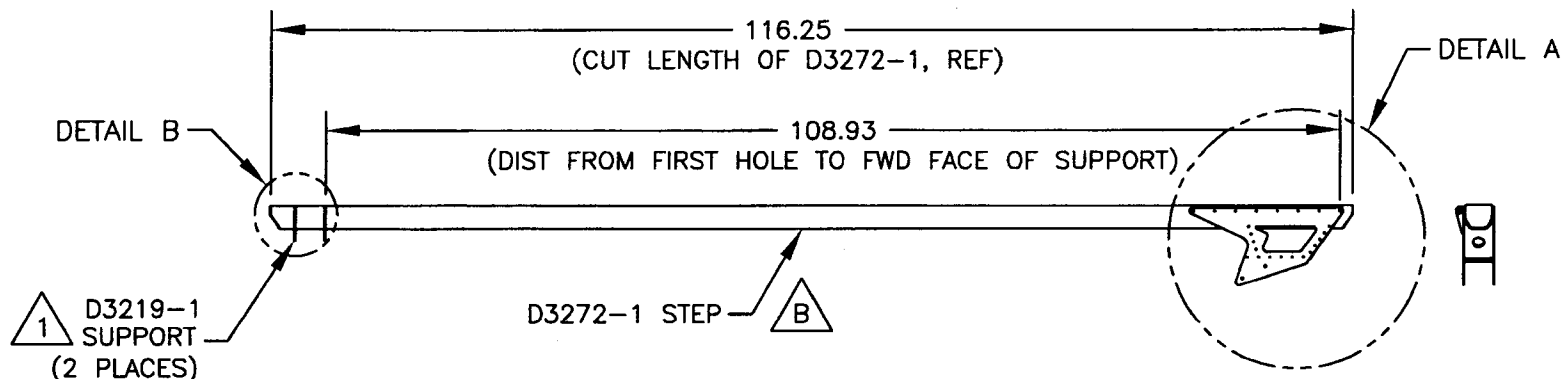
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

Wb 70327

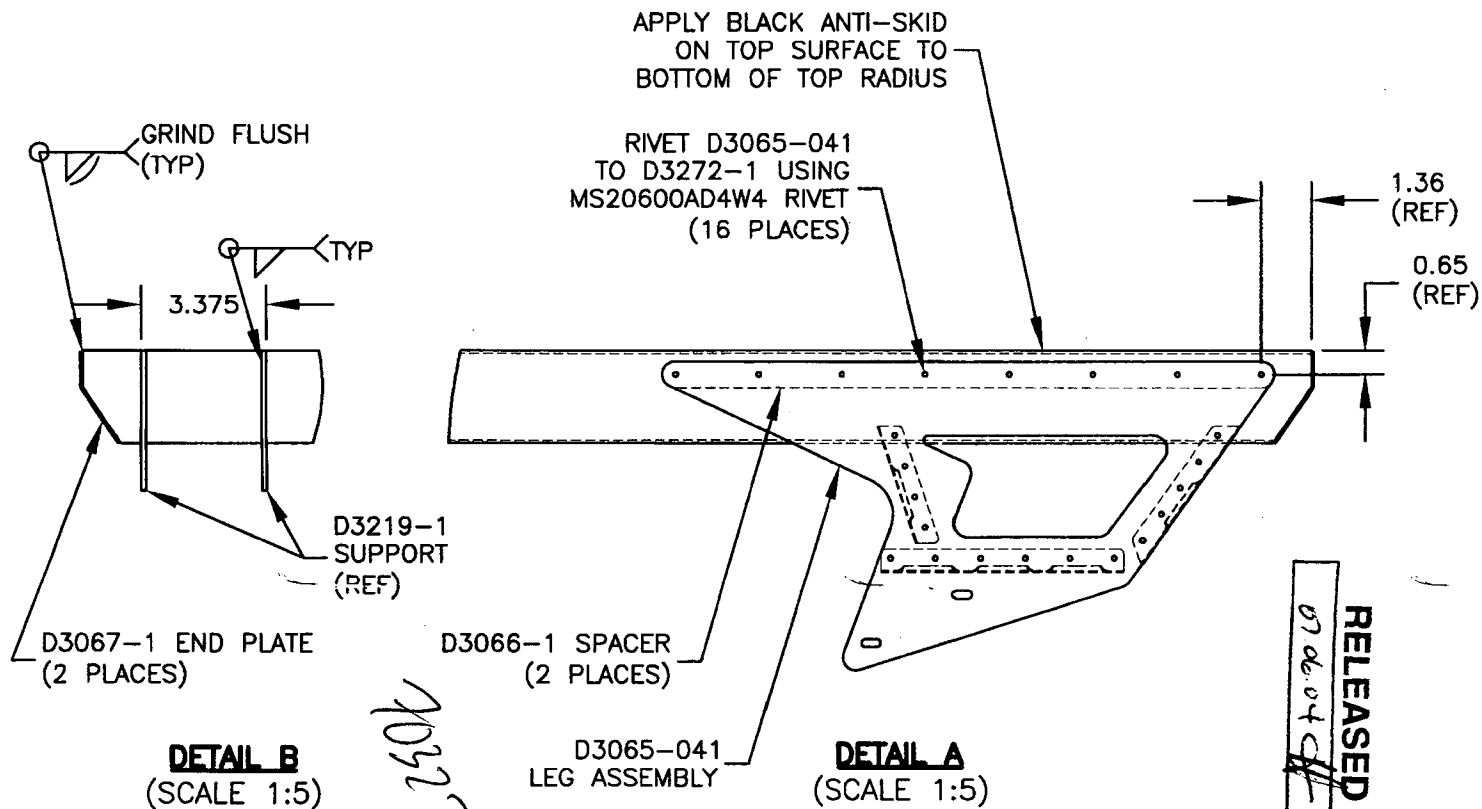
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



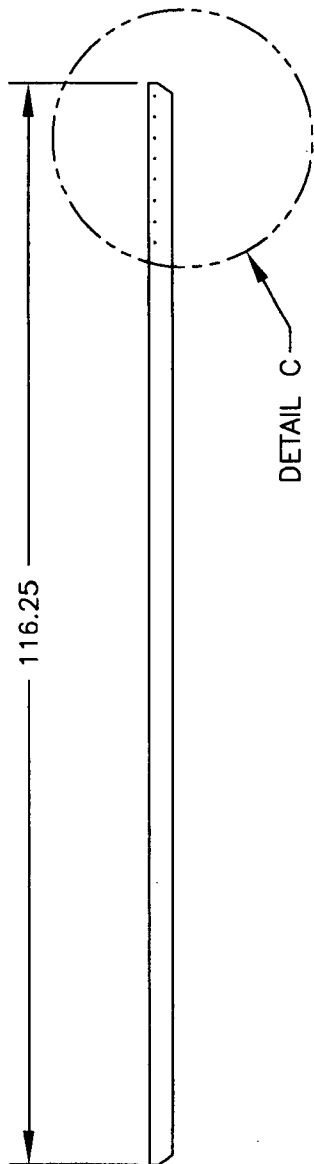
DESIGN	qo	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	MR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

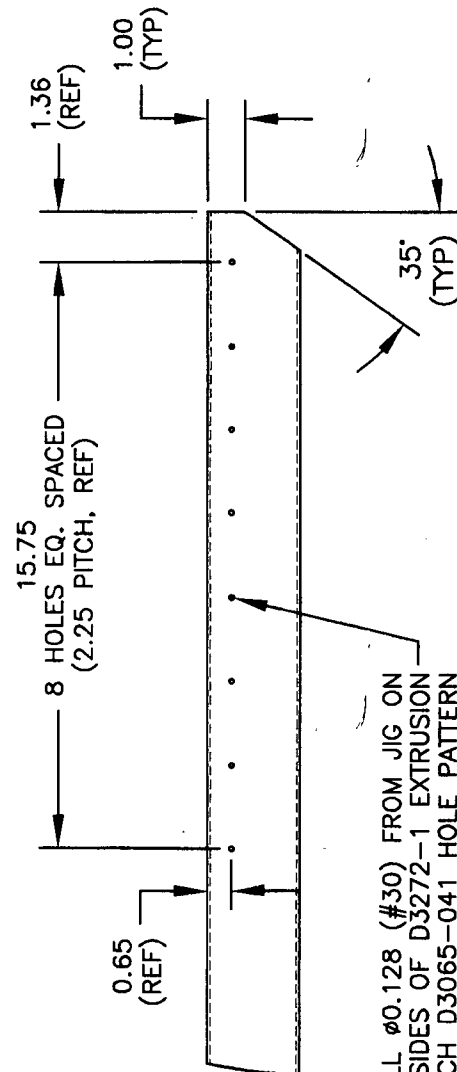
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

C DETAIL C
(SCALE 1:5)

70327

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D350-591

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.